

Bush Aircraft Corporation

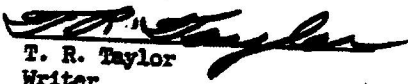
# OVERHAUL SPECIFICATION

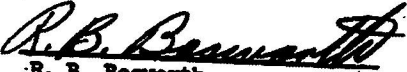
FUSELAGE ASSEMBLY - MODEL C-450, C-45R, AND SNB-5

OVERHAUL SPECIFICATION 4001

ISSUED April 23, 1953

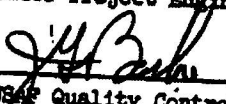
REVISED August 10, 1953

  
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TITLE FUSELAGE ASSEMBLY - MODEL C-45G, C-45H, AND SNB-5

ISSUED April 23, 1953

WRITTEN BY *W. Taylor* REVISED August 10, 1953

**1. SCOPE**

1.1 Purpose.- The purpose of this specification is to authorize the use of reconditioned parts and provide reconditioning instructions for component parts of the fuselages as installed in Air Force and Navy aircraft received for overhaul and instructions for modifications required to adapt them for installation in Model C-45G aircraft in accordance with Drawing 694-184000, Model C-45H aircraft in accordance with Drawing 694-184000-14, and Model SNB-5 aircraft in accordance with Drawing 894-184001.

1.2 Application.- All reconditioning operations and repairs covered by this specification may be accomplished where required without further authorization. Repairs not authorized by this specification cannot be performed without further authorization.

1.3 List of Pages and Revisions.- This specification consists of the pages listed below. An asterisk (\*) denotes the pages revised by the current revision.

<u>Page</u>	<u>Date</u>	<u>Description of Revision</u>	<u>Serial Effectivity</u>
1*	8-10-53	Incorporate SNB-5	Record change
2*	8-10-53	Incorporate SNB-5	Record change
3*	8-10-53	Incorporate SNB-5	Record change
4*	8-10-53	Incorporate SNB-5	Record change
5*	8-10-53	Incorporate SNB-5	Record change
6*	8-10-53	Incorporate SNB-5	Record change
7*	8-10-53	Incorporate SNB-5	Record change
8*	8-10-53	Incorporate SNB-5	Record change
9*	8-10-53	Incorporate SNB-5	Record change
10*	8-10-53	Incorporate SNB-5	Record change

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2. **APPLICABLE PUBLICATIONS**

2.1 **Federal.-**

QQ-F-416 Cadmium Plating

2.2 **Boech.-**

- FS 302 Finish Specification for Overhauled Navy SNB/JRB Aircraft
- FS 370 Finish Specification for C-45G and C-45H Aircraft
- OS 3401 Radio System - Model C-45G and C-45H
- OS 3402 Radio System - Model SNB-5
- OS 4010 Fuselage Doors - Model C-45G, C-45H, and SNB-5 Aircraft
- OS 5310 Floor Board Installation - Model C-45G and C-45H
- OS 7002 Cleaning Procedures for Reconditioned Aircraft
- OS 7003 Air Frame and Control Antifriction Bearings
- OS 7007 Sheet Metal Repairs
- OS 7008 General Acceptable Quality Standards
- OS 7010 Removing Corrosion from Aluminum Parts

3. **REQUIREMENTS**

3.1 **Parts Involved.-** For parts involved in addition to those covered by this specification, refer to the overhaul specifications listed below.

- OS 3401 Radio System - Model C-45G and C-45H
- OS 3402 Radio System - Model SNB-5
- OS 4010 Fuselage Doors - Model C-45G, C-45H, and SNB-5 Aircraft
- OS 5310 Floor Board Installation - Model C-45G and C-45H

3.1.1 **Parts Not Used.-** All parts and assemblies listed on Drawings 1840000, 804-184000, 824-184000, 764-184000, 84-184000, and 784-184000 will be disposed of at the direction of the customer except those items listed in Paragraph 3.1.2 of this specification.

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**3.1.2 Parts to be Reconditioned.**- The following parts are to be reconditioned in accordance with the instructions contained herein. "Reconditioned" means the disassembly, cleaning, inspection and correction of discrepancies, repair and/or replacement of components, and modifications to incorporate changes in accordance with applicable engineering drawings to assure an operationally safe and serviceable aircraft.

**3.1.2.1 Fuselage Assemblies 184000U, 804-184000, 824-184000, 764-184000, 84-184000, and 785-184000.**

18528-5	Strap installation
18526	Nose baggage compartment door
404-185260	Nose baggage compartment door
185670P	Cabin door holder installation
84-185600	Cabin door assembly
18560	Cabin door assembly

**3.1.2.2 Pilots Compartment Floor Board Installation 18312.**

183121-1	Reinforcement
183121-2	Reinforcement
183124	Cover
187509A	Hold down
183149	Plate
183137	Plate

**3.1.2.3 Pilots Floor Inspection Door Latch Installation 183123.**

183123-2	Plate
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**3.1.2.4 Cabin Floor Board Installation 18310.**

183103	Left floor assembly
183104	Right floor assembly
183108	Forward floor assembly
183109	Rear floor assembly

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- 3.1.2.5 Bulkhead Assembly 18413.-  
18413-4 "X" Brace assembly
- 3.1.2.6 Bulkhead Assembly 18415.-  
184151 Bracket  
184152 Bolt
- 3.1.2.7 Storm Window Installation 185530.-  
185532 Latch  
185536 Latch
- 3.1.2.8 Bulkhead Assembly 84-184030.-  
84-184031 Guard
- 3.1.2.9 Pilots Compartment Floor Board Installation 804-183120.-  
804-183138 Door assembly
- 3.1.2.10 Nose Baggage Compartment Door Lock Installation 185270.-  
185274 Striker block
- 3.1.2.11 Furnishings Installation 84-180630.-  
184096P Door
- 3.1.2.12 Radio Antenna Installation 180450P.-  
180806P Antenna brace anchor

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WRITTEN BY *T. P. Taylor*

REVISED August 10, 1953

3.1.2.13 Hydraulic Brake Fluid Supply Tank Installation 187920.-

187921 Bracket

3.1.2.14 Storm Window Frame Assembly 185531.-

185534 Catch

3.1.2.15 Radio Antenna Assembly 84-180451.-

84-180805 Radio antenna mast assembly

3.1.2.16 Phenolite Guide Blocks.- All

3.1.2.17 Windshield and Pilots Windows Installation 18550.-

18551-2L	Windshield curved left-hand glass
18551-2R	Windshield curved right-hand glass
18551-4	Windshield side glass
18551-3	Storm window glass
804-185512	Pilot sliding window glass assembly
804-185512-1	Pilot sliding window glass assembly
18552-1	Windshield center glass
18552-2	Pilots triangular window glass
18552-4	Pilots side window glass

3.1.3 Parts to be Supplied New.- The parts listed below and all parts called out on Drawing 894-184001 for the SNB-5 and on Drawing 694-184000 for the C-45G and 694-184000-14 for the C-45H, will be supplied new except those parts listed in Paragraph 3.1.2 of this specification.

561-D8-4	Curtiss clamp, 2 required
AN741-6	Clamp, 1 required

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ISSUED April 23, 1953

WRITTEN BY *T. D. Taylor*

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3.2 Cause for Rejection.- Damage or wear which cannot be corrected by one or more of the authorized repairs listed in Paragraph 3.4 of this specification is cause for rejection.

3.3 Reconditioning Operations:

3.3.1 "X" Brace Assembly 18413-4.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Weld up the 8 holes in the lugs, and refill 4 holes (.200) in each lug to match attaching holes in Number 13 bulkhead.  
(.193)
- (d) Torch stress relieve the weld area by concentrating the torch flame directly on the weld bead. Heating should be stopped when a red color first begins to appear.
- (e) Make OS 4001-1 weld assembly by welding Curtiss clamps to AN741-6 clamp (as shown in Figure 1) rather than to 43-184135 brace as shown on face of Drawing 18413-4. Weld clamps so that the 19° angle as shown on the face of the drawing is maintained, and locate OS 4001-1 so that the Curtiss clamps are in the same position as shown on the drawing.
- (f) Magnetic-particle inspect after welding in accordance with Specification MIL-I-6868.
- (g) Should a lincol leak develop in the completed "X" brace around the present drive screw, remove drive screw, clean out hole and replace with a drive screw one size larger.
- (h) Sandblast completed "X" brace assembly.
- (i) Finish in accordance with FS 302 or FS 370 as applicable.

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3.3.2 All Phenolic Blocks.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean.
- (c) Shellac with clean commercial shellac.

3.3.3 Strap Installation 18528-5.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean buckle.

3.3.4 Bracket Assembly 184151, Brace Assembly 18418-1.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Re-weld if necessary with wire, class MIL-R-5632.
- (d) Reheat-treat 184151 and 18418-1 after welding.
- (e) Finish in accordance with FS 302 or FS 370 as applicable.
- (f) Magnetic-particles inspect in accordance with MIL-I-6868.

3.3.5 Cabin Door Holder 185670P.-

- (a) Disassemble.
- (b) Replace 184681 loop assembly.
- (c) Finish in accordance with FS 302 or FS 370 as applicable.

3.3.6 Guard 84-184031; Reinforcement 183121-1 and 183121-2, Cover 183124; Plates 183149, 183137, and 183123-2; Holddown 187509A; Catch 185534; and Bracket 187921.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Finish in accordance with FS 302 or FS 370 as applicable.

3.3.7 Latches 185532 and 185536 and Antenna Brace Anchor 180806P.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Finish in accordance with FS 302 or FS 370 as applicable.



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3.3.8 Striker Block 185274 and Bolt Stop 184152.-

- (a) Inspect for nonrepairable conditions.
- (b) Clean in accordance with OS 7002.
- (c) Cadmium plate in accordance with Specification QQ-P-416.

3.3.9 Windshield Curved Left-Hand Glass 18551-2L; Windshield Curved Right-Hand Glass 18551-2R; Windshield Side Glass 18551-4; Storm Window Glass 18551-3; Pilot Sliding Window Glass Assembly 804-185512; Windshield Center Glass 18552-1; Pilots' Triangular Window Glass 18552-2; Pilots' Side Window Glass 18552-4.-

- (a) Inspect for nonrepairable conditions.
- (b) Rinse with clean water.
- (c) Wash with mild soap and water and remove all traces of sealer.
- (d) Rinse with clean water.
- (e) Dry with soft clean cloth.
- (f) Modify the 804-185512 sliding window assembly to conform to Drawing 404-185507. Remove the 804-185511 knobs and relocate them to the dimensions shown on Drawing 404-185512. The knobs may be removed by gently prying with a putty knife blade after soaking for 2 minutes under hot running water. Relocate the knobs using EC 1294 cement in accordance with Beech Specification 201. The notches cut in the edges of the glass in accordance with Drawing 804-185510 are acceptable without rework.
- (g) Install in accordance with Drawing 894-185500 for the SNB-5, C-45G, and C-45H.

3.4 Authorized Repairs:

3.4.1 Bracket Assembly 184151; Brace Assembly 18418-1; Cabin Door Holder 185670P; Cover 183124; Plates 183149, 183137, and 183123-2; and Bracket 187921.-

- (a) Straighten parts as necessary in accordance with shop practice.

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WRITTEN BY J.P. Taylor REVISED V August 10, 1953

4. INSPECTION

4.1 General.- The parts will be inspected to the general acceptable standards of CS 7008.

4.2 Windshield and Pilots Compartment Glass.- Windshield and pilots compartment glass with nicks, chips, or separation and discoloration at the edges that do not extend beyond the edge of the frame are acceptable. Minor pits, hairline scratches, and other minor defects that do not affect the optic quality of the glass when looking through the glass will not be cause for rejection. Nicks, chips, and scratches may be buffed lightly to produce a smooth surface or a radius.

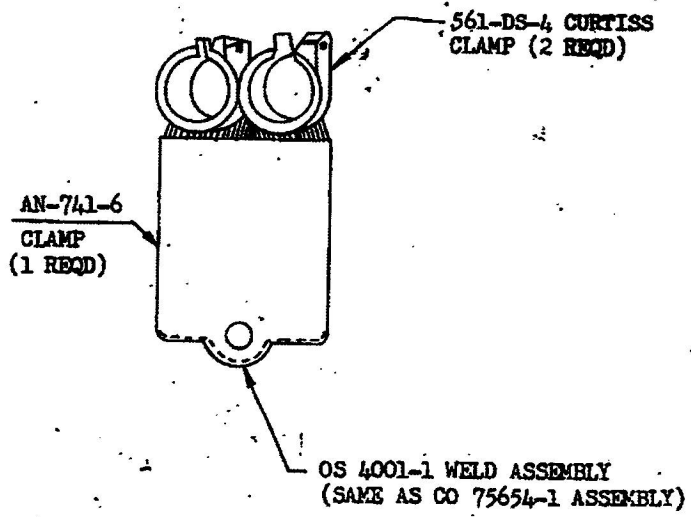


FIGURE 1.

WRITTEN BY <i>F. M. Polk</i>	DATE ISSUED 4-23-53	<b>OVERHAUL SPECIFICATION</b>	
PROJECT ENGINEER <i>[Signature]</i>		FUSELAGE ASSEMBLY - MODEL C-45G, C-45H, AND SNB-5	
APPROVAL <i>[Signature]</i>	DATE REVISED 8-10-53	Beech Aircraft CORPORATION Wichita 1, Kansas	OVERHAUL SPECIFICATION NO. 4001
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